

Work Order ID 63806

Monday, November 15, 2010 8:35:05 AM



Page 1

Item ID:	D3436-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step LH					
Start Date:	11/15/2010	Start Qty:	3.00			
Required Date:	11/22/2010	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-16	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3436	Rev A								
100	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436Dwg Rev: <input type="checkbox"/> Qty Part Number Description								
	Batch <input type="checkbox"/> A/RN/A 4130 Welding Rod <u>m19317</u> <input type="checkbox"/> Weld								
	left step D3436-7 using welding Jig DT								
110	BAND SAW	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	1- Slit part D3436-041 on bandsaw as per Dwg D3436 deburr								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11.01.13

3

11.01.13

3

3

BE 11/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>3</u> 47			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <u>M115391</u> Memo Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4 START TIME: <u>10:45</u> OVEN TEMPERATURE: <u>11:15</u> FINISH TIME: <u>11:15</u> Wing Walk batch: <u>M115390</u>	0.00 0.00				<u>3</u>		<u>BR 11-01-17.</u>	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>3</u>			<u>11/01/17</u> <u>3</u>

W/O:		WORK ORDER CHANGES					
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Item Name: Step LH

Start Date: 11/15/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

0.00



Small Fab

Memo

0.00

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

Signature 11/01/10 (3)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Signature

43

44

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PP63808 1x

PP64 5/06 2x

Signature 11/01/10 (3)

Dart Aerospace Ltd

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Setup Start



Revision ID:

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Item Name: Step LH

Start Date: 11/15/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19

11-01-19

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NOTE: Date & initial all entries

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Page 1

...the ...

[illegible]

Required Date: 11/22/2010

Required Qty: 3.00

Comments: IPP .A 05.05.11 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-1 		Manufactured	No			100	Each	49.0000	1	3			
Clamp													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				49		3			
					<u>17679</u>			49					
D3436-3 		Manufactured	No			100	Each	4.0000	1	3			
Left Step													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4		3			
					<u>56841</u>			4					
D3436-5 		Manufactured	No			100	Each	19.0000	4	12			
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				19		12			
					<u>364065</u>			19					
					<u>56893</u>								
D3436-9 		Manufactured	No			100	Each	6.0000	2	6			
Pad													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST056				6					
					<u>56830</u>			6					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:35:09 AM

Page 2

Work Order ID: 63806

Parent Item: D3436-043

Parent Item Name: Step LH



Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 3.00

Required Qty: 3.00

D3436-7

Manufactured No

160

Each

40.0000

1

3



Cap



SE 11.01.13

Location

Loc Qty

Loc Code

WA

40

56836

40

3

Monday, November 15, 2010 8:35:09 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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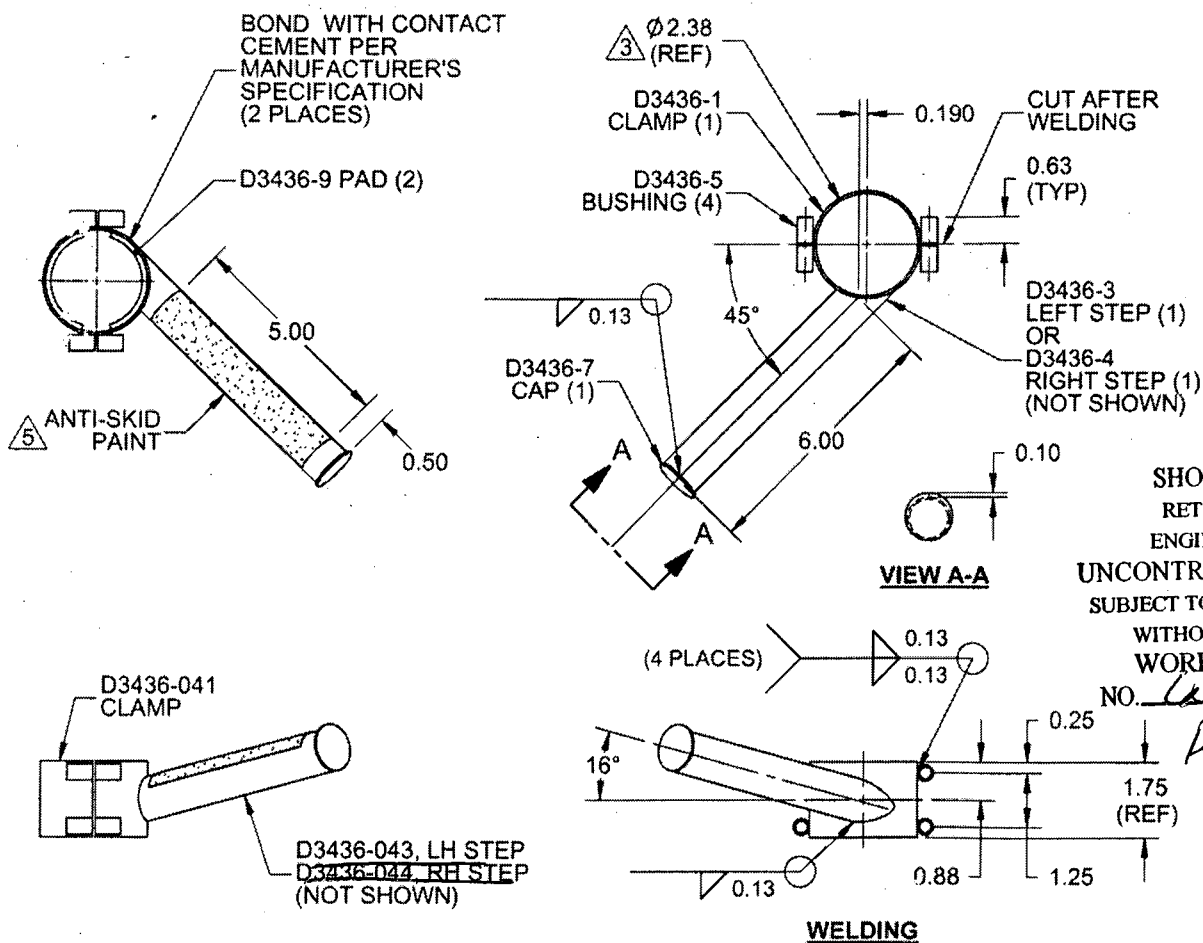
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NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63804
PP10-11-15

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27 [Signature]

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Dart Aerospace Ltd

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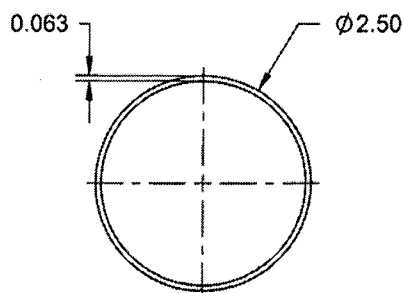
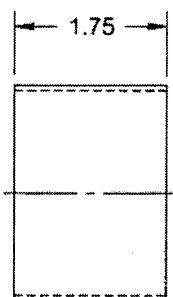
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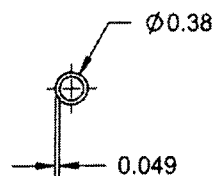
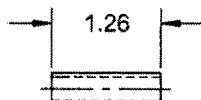
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

w/ 63809



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

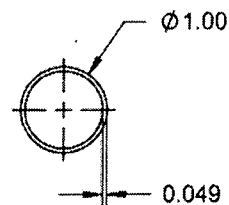
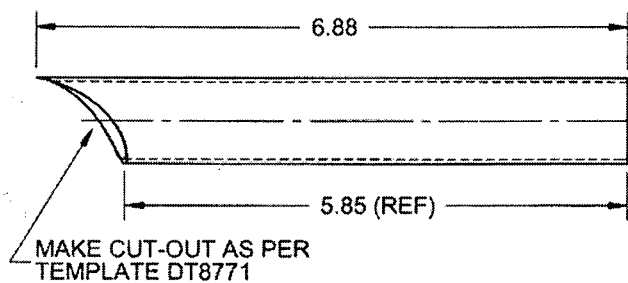
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

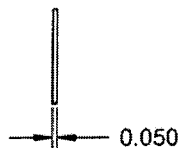
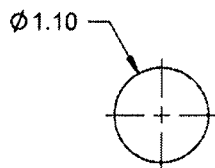
ulb 43804



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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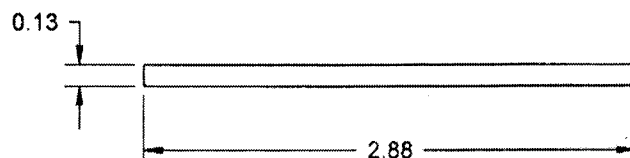
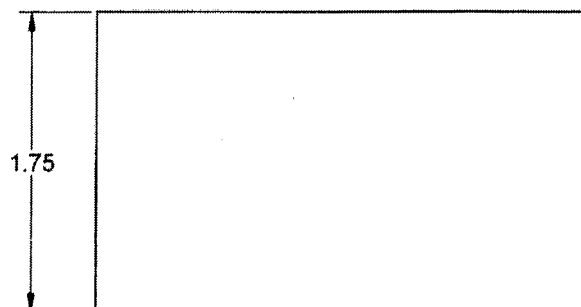
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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1

w/o 43864



RELEASED
05-05-27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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